



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5559-041
Job Sheet 195994



Part No: D5559-041

Job Qty: 2 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 7/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg D5559 Rev.B IPP REV:A 17.10.17 NEW ISSUE DD VERF:JFS IPP Rev.B Updated Bom per Dwg Rev.B
18/03/01 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2		7/15/19	0.17	0.31	Waterjet - Flow		
		pcs							
110	QC 2	2		7/15/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
							QC 2 - 73		
							QC 2 - 69		
120	QC 8	2		7/15/19	0.00	0.00	QC 8 - 12		
		pcs					QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		

See other work
order attached.
100, 110, 120

Plex 6/25/19 2:41 PM Dart.Renwick.Jennife

					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
128	Small Fab - Brake NC - B4B	2 pcs	7/15/19	0.00 0.00	Small Fab - Brake - 1 - B4B	9-89 30 DAS JUN 25 2019
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
129	QC 5	2 pcs	7/15/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	DAS 40
					QC 5 - 19	
					QC 5 - 22	JUN 27 2019 9-89
					QC 5 - 43	
130	Large Fab - Welded Assy-2-B4B	2 pcs	7/15/19	0.00 3.39	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	ms
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
140	QC 9	2 pcs	7/15/19	0.00 0.00	QC 9 - 10	68-6 9-89 DAS 24 JUL 04 2019
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	DAS 9-89
					QC 9 - 50	
					QC 9 - 9	
150	QC 5	2 pcs	7/15/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	68-6 9-89 DAS 24 JUL 04 2019
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS 9-89
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
180	Packaging 3-1 - Stock - B4B	2 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

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				Packaging 3 - 3 - B4B			
				Packaging 3 - 4 - B4B			
				Packaging 3 - 5 - B4B			
				Packaging 3 - 6 - B4B			
				Packaging 3 - 7 - B4B			
				Packaging 3 - 8 - B4B			
				Packaging 3 - 9 - B4B			
				Packaging 3 - 10 - B4B			
				Packaging 3 - 11 - B4B			
				Packaging 3 - 12 - B4B			
				Packaging 3 - 13 - B4B			
				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
				Packaging 3 - 17 - B4B			
				Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
190	QC 21 - SA	2	7/15/19	0.00 0.00	QC 21 - SA - 21		
		pcs			QC 21 - SA - 70		
					QC 21 - SA - 53		
Part Op 100 - 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 128 - Bend as per dwg. 130 - (Weld per dwg A/R S.S. rod Batch: <u>M13874</u>), 1-Weld D3009-3 cups as per dwg D5559 A/R 316L stainless steel rod : _____ 1- WELD HARDCOAT TO PLATE 2059B HARDCOAT BATCH: _____ 140 - (QC9- Inspect visual per QSI004- Fusion Welds) 150 - (QC5- Inspect part completeness to step on W/O) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
M304S16GA	304/316 Sheet .063	1.3600 sf (.68 ea)	100-Waterjet - Flow - 1				
D3009-3	Cup	16 pcs (8 ea)	130-Large Fab - Welded Assy-2- B4B				
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-Waterjet - Flow - 1	M304S16GA	1	289	0			
130-Large Fab - Welded Assy-2- B4B	D3009-3	16	108	0			
Part Specifications							
Specifications could not be found.							

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Part No: D5559-041

Job Qty: 2 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg D5559 Rev.B IPP REV:A 17.10.17 NEW ISSUE DD VERF:JFS IPP Rev.B Updated Bom per Dwg Rev.B
18/03/01 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier		
100	Waterjet - Flow - 1	2 pcs		6/14/19	0.17	0.31	Waterjet - Flow		JRB 6/24/19
110	QC 2	2 pcs		6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									

Plex 6/4/19 10:37 AM Dart.lajeunesse.marie

6/4/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	2 pcs	6/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 6/24/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JUN 25 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Large Fab - Welded Assy-2-B4B	2 pcs	6/14/19	0.00 3.39	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	mf
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
140 QC 9	2 pcs	6/14/19	0.00 0.00	Large Fab - 11 - B4B (Various)	
				QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
150 QC 5	2 pcs	6/14/19	0.00 0.00	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

DAS
40
9-89

JUN 25 2019

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180	Packaging 3-1 - Stock - B4B	2 pcs	6/14/19	0.00 0.00	QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST 611
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	2 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Weld per dwg A/R S.S. rod Batch: M138977, 1-Weld D3009-3 cups as per dwg D5559 A/R 316L stainless steel rod : _____ 1- WELD HARDCOAT TO PLATE 2059B HARDCOAT BATCH: _____
 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
 150 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.3600 sf (.68 ea)	100-Waterjet - Flow - 1	519460
D3009-3	Cup	16 pcs (8 ea)	130-Large Fab - Welded Assy-2- B4B	5192750

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	329	0
130-Large Fab - Welded Assy-2- B4B	D3009-3	16	52	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART

AEROSPACE

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1270 Aberdeen Street

Hamletbury, ON K64 1K7

Canada

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Email: sales@dartaero.com

www.dartaero.com

Container No: S193340

Part: D5559-041

Job No: 195994

Serial No/Batch: S193340

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/24/19